

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	19519
<b>Description: DOUBLER</b>	<b>Part Number:</b>	D3140-95
<b>Drawing: D3140 Rev A1</b> page 5 RF 02.12.10	<b>Qty:</b>	12

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	ml	03.08.22	12
2	METAL	Cut as per dwg D3140 Matl: 2024-T3 ( QQ-A-250/4 ) .032" thick ( M2024T3S.032 ) 6.40" x 3.81" flat pattern ref. NOTE GRAIN DIRECTION Batch # M 11930 ml M 10715	ml	03-08-22	12
3	METAL	Deburr. No sharp edges	ml	03-08-22	12
4	METAL	Form as per dwg 106" revision	ml	03-08-25	12
5	QC	Inspect Level 5	ml	03-08-26	12
6A	FINISHING	Chemical conversion coat per QSI 005 4.1.	ml	03-08-26	12
6B	QC3	Inspect work to step 6A	ml	03-08-27	12
7	STORES	Identify & stock.	ml	03-08-27	12
8	EXPEDITING	Close W/O Inspect level 21. Job Cost/ Job 8.35 54505/08/28 (12) 678	ml	03.09.02	-

Rev.	Date	Change	Revised By	Approved
A	02.04.30	New Issue	NG	02-05-27

RELEASED

02/05/23

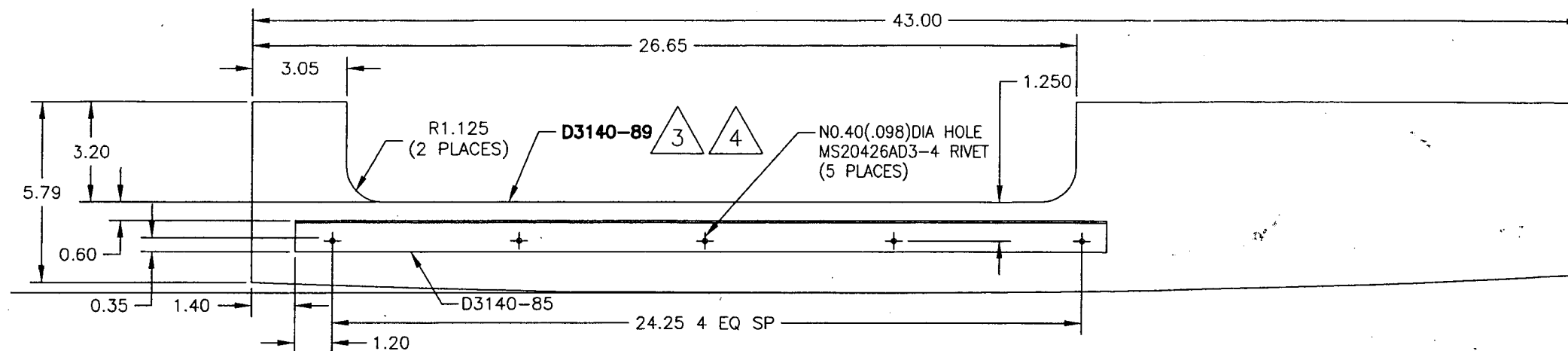
Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

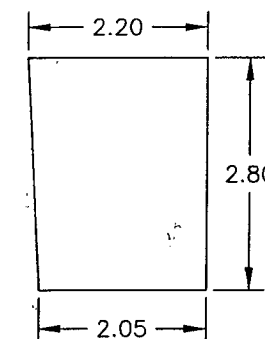
PAR#:\_\_\_\_\_ Fault Category:\_\_\_\_\_ DQA:\_\_\_\_\_ Date:\_\_\_\_\_

**NOTE:** Date & initial all entries  
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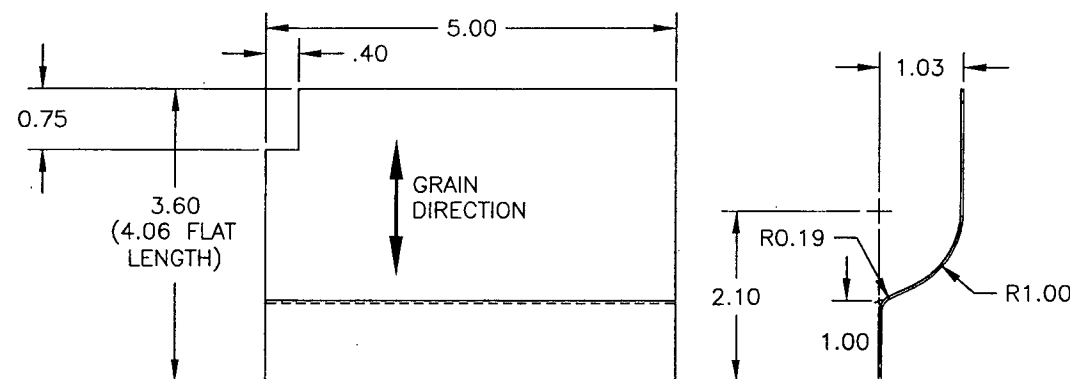
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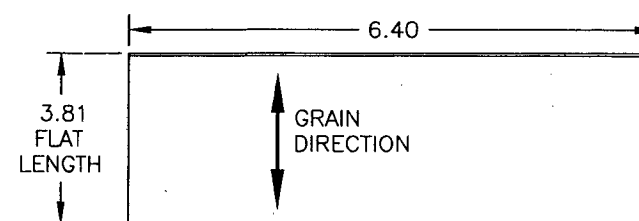
**D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)**  
**D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)**



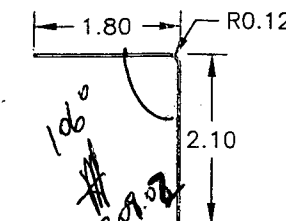
**D3140-101 DOUBLER** (4)  
 (REPLACES PREMIER P/N B30-23000-101)



**D3140-91 DOUBLER** (4)  
 (SHOWN, REPLACES PREMIER P/N B30-23000-91)  
**D3140-92 DOUBLER**  
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)



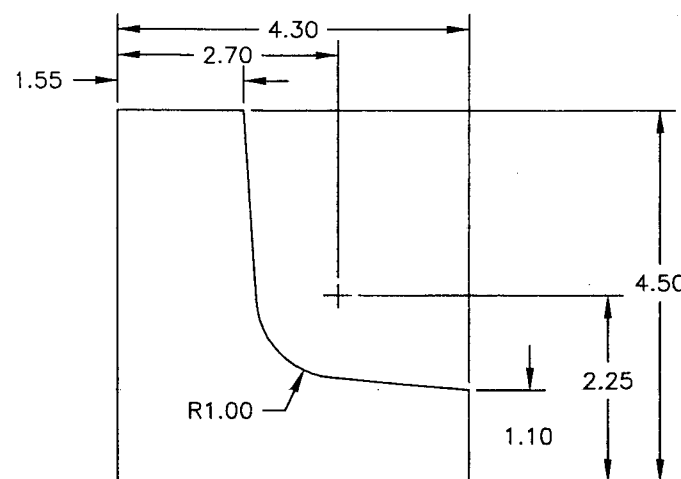
**D3140-95 DOUBLER** (4)  
 (REPLACES PREMIER P/N B30-23000-95)



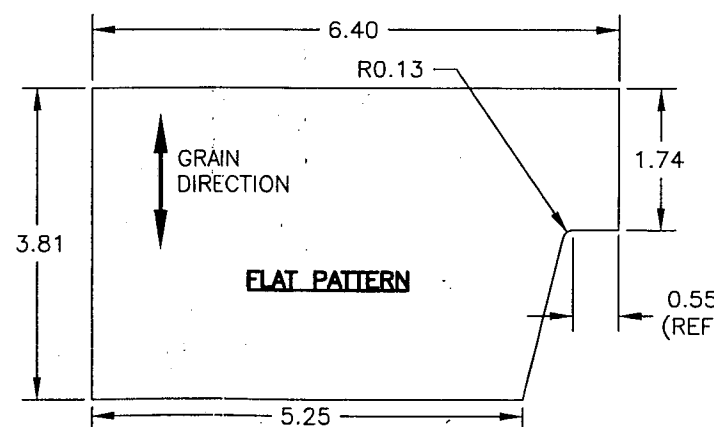
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 03.01.23

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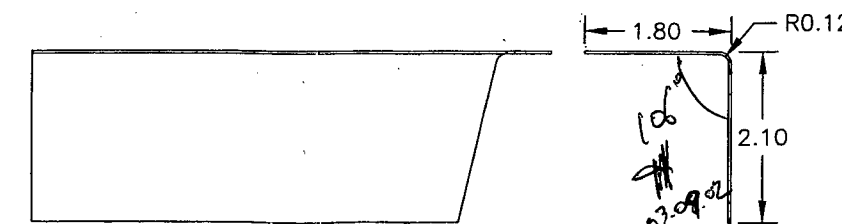
**WORK ORDER**  
 NO. 19519



**D3140-99 DOUBLER** (4)  
 (REPLACES PREMIER P/N B30-23000-99)



**D3140-97 DOUBLER** (4)  
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)  
**D3140-98 DOUBLER**  
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)



**BEND DETAIL**

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DESIGN	DRAWN BY
CHECKED	APPROVED
DATE	
03.01.23	

<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3140	REV. B SHEET 5 OF 7
TITLE DOOR	SCALE NTS



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 22, 2003  
11:30 am

Work Order No : 0019519  
Project Name : D3140-95  
Project For : WK334  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3140-95  
Description : Doubler  
Manufactured : Yes  
Amount Req'd : 12  
Amount Done : 0  
Start Date : 08-22-03  
Est Finish Date : 08-22-03  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00